

Work Order ID 58668

May 13, 2010 1:23:31 PM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 14/05/2010 Start Qty: 8.00

Required Date: 22/05/2010 Req'd Qty: 8.00

Cust Item ID:

Customer:

Reference: *10.05.13*

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2572

Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS I

0.00

HAAS CNC vertical machine #1

Memo

Program Batch No. *58668*

Double check by: *M.A.*

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

10.5.15
M.A. 10/05/18

8 *8*

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

0.00

Conventional Milling Machine

Memo

Machine keyway as per dwg D2571 & D2572

10.5.16
M.A. 10/05/18

8 *8*

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Page 2

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Sequence ID/
Work Center ID

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Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

out 10-5-16
M.A 10/05/18

8

Ø

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

out 10/05/19

8

Ø

140

Chemical Conversion Coat per QS1005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

BR 10-5-20

Work Order ID 58668

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Page 3

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Start Date: 14/05/2010 Start Qty: 8.00



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Required Date: 22/05/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:00pm
310°F
1:30pm

=> 10/05/20

8 0

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

8 BR 10-5-20

170

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

433

10-5-20 825

Work Order ID 58668

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Page 4

Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 14/05/2010 Start Qty: 8.00



Cust Item ID:

Required Date: 22/05/2010 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/05/25
MF
10-5-22

Picklist Print

May 13, 2010 1:23:30 PM

Page 1

Work Order ID: 58668



Parent Item: D2572

Parent Item Name: Saddle. Fwd In 205

Start Date: 14/05/2010

Required Date: 22/05/2010

Comments: IPP: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated
D2572 KJ

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
D6101-005		Manufactured	No			100	Each	62.0000	1			



Saddle Billet



Location

Loc Qty

Loc Code

MAT46

62

46411

62

ref 10-5-15

8

DART AEROSPACE LTD	Work Order:	58668
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.438	0.443		0.440	0.440	0.440	0.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.002	8.002		
F	0.490	0.510		0.497	0.495	0.496	0.498		
G	0.257	0.262		0.259	0.259	0.259	0.259		
H	0.375	0.380		0.377	0.377	0.377	0.377		
I	0.490	0.510		0.499	0.499	0.499	0.499		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		0.565	0.566	0.568	0.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		0.122	0.122	0.122	0.122		
Q	0.115	0.135		0.135	0.135	0.135	0.135		
R	0.240	0.260		0.247	0.247	0.247	0.247		
S	0.115	0.135		0.122	0.121	0.123	0.123		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.963	2.963	2.963	2.963		
V	0.230	0.250		0.239	0.238	0.236	0.238		
W	0.115	0.135		0.126	0.130	0.131	0.130		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.762	0.762	0.762	0.762		
Z	0.352	0.372		0.361	0.363	0.363	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.627	0.627	0.627	0.627		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.241	0.241	0.241	0.241		
AE	1.375	1.395		1.385	1.385	1.387	1.3875		
AF	0.115	0.135		0.135	0.135	0.135	0.135		
AG	0.240	0.280		0.245	0.245	0.245	0.245		
AH	0.240	0.260		0.247	0.247	0.247	0.247		
AI	2.000	2.020		2.002	2.003	2.003	2.0037		
AJ	0.023	0.043		0.033	0.033	0.033	0.033		
Accept/Reject									

Measured by:	K.A
Date:	10/05/18

Audited by:	ML
Date:	10/05/18

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	58668
Description: Saddle, Fwd Inboard	Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

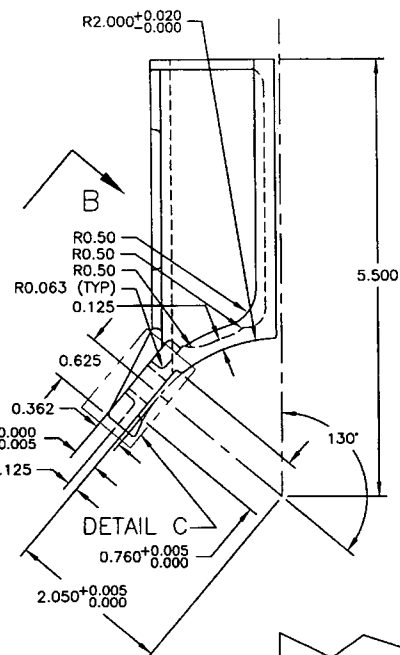
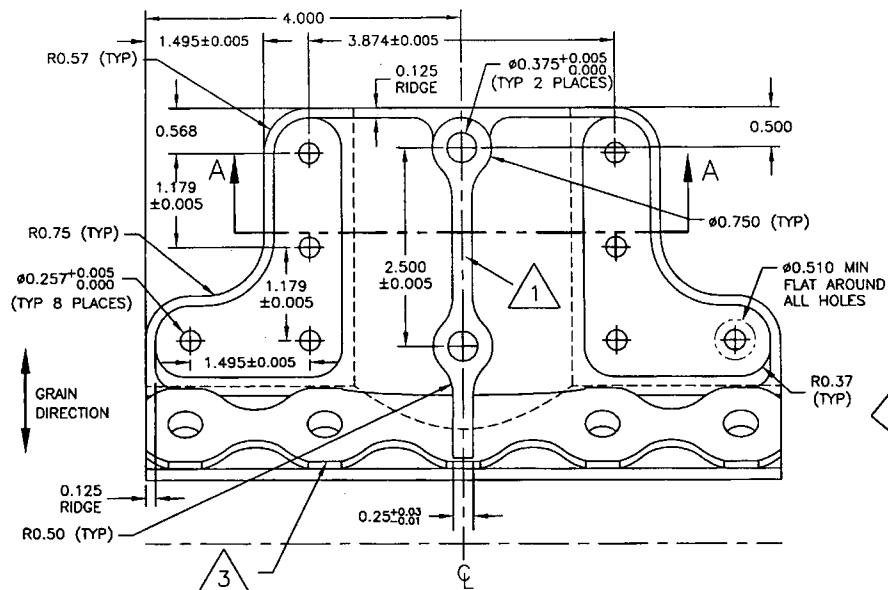
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D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.003	8.003	8.003	8.003		
F	0.490	0.510		.498	.498	.498	.498		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.502	.502	.502	.502		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.569	.569	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
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R	0.240	0.260		.247	.247	.247	.247		
S	0.115	0.135		.129	.129	.129	.129		
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U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.235	.235	.235	.235		
W	0.115	0.135		.129	.129	.129	.129		
X	0.307	0.312		.310	.310	.310	.310		
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AH	0.240	0.260		.245	.245	.245	.245		
AI	2.000	2.020		2.002	2.002	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>
Date: 10.5.16	Date: 10/6/19





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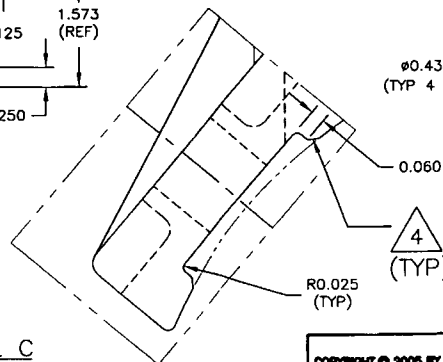
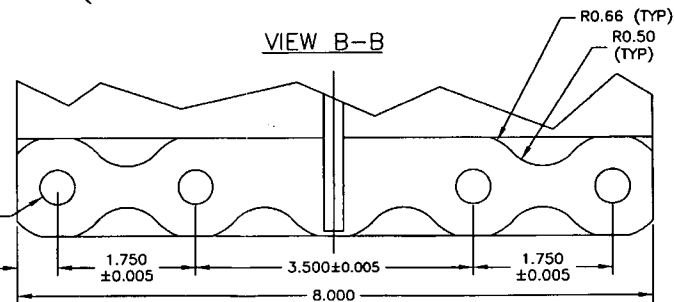
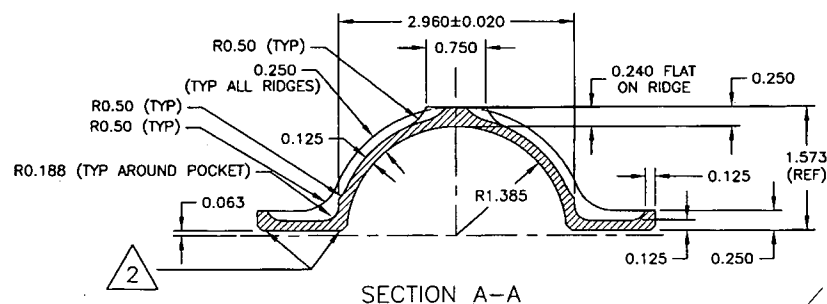
05.12.06 *[Signature]*






NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- | | |
|---|--|
|  | ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010 |
|  | CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES) |
|  | CHAMFER 0.063 x 45° ALL AROUND |
|  | CHAMFER 0.033 x 45° (SEE DETAIL C) |
-



DETAIL C
SCALE 2:1

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN DS DRAWN BY PH  DART AEROSPACE LTD. MARKHAM, ONTARIO, CANADA		REV.
CHECKED 	APPROVED 	DRAWING NO. D2572
DATE 05.07.13		TITLE INNER FWD SADDLE
		SCALE 2: